

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006642**Date Inspected:** 07-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/07/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4, Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Assembled section is being laid down to allow for a 1G (Flat) weld of Cast stem to Plate stem.

W2W1 - Welders D.Kito 08-5175 and R.Iizuka 06-2643, Shielded Metal Arc Welding (SMAW) of temporary lifting lugs to buttering on casting, at ends outside trough.

W2W2 - Plate rib being welded to Base Plate, joint W2Y-8L by T.Watanabe 08-5153 using procedure SJ-3011-2.

Plate rib to plate stem, joint W2Y-7V, is in process by welder M.Kashiwada 08-2008 per SJ-3011-3, both welders are using Flux Core Arc welding (FCAW) process, 1.6mm weld wire.

W2W3 - Plate build up section is starting beginning fitup with tacks, observed piece marks 6-9,-10,-11,-12 being fit up by Y.Ohta 08-2017, tacks were being deposited per procedure SJ-3011-11 using Shielded Metal Arc process 4mm E9018M electrode, CWI verified preheat of 160 degree Celsius.

Tower Saddles:

T1-3 - Two welders, K.Sadakawa 06-2929 and T.Ohkawa 03-91, are actively performing Shielded Metal Arc Welding (SMAW) process to deposit root pass of welds 9Y-10U and 9Y-9U using 4mm, E7016 electrode, per SJ-3012-4 procedure.

Assigned Caltrans Lot number B275-011-09 to six (6) Material Test Reports (MTR) witnessed and reviewed for

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the forged Rockers; heat numbers 09D13-7-1~3, 09D13-9-1~3, 09D13-10-1~3, 09D13-11-1~3, 09D13-12-1~3, 09D13-13-1~3. Verified test results per ASTM A668 Class J, processes were Brinell hardness testing and tensile test.

Observed bend test of of four (4) welders, FCAW 1G position, welder ID's of 08-5173, 08-5174, 08-5175, 08-5176. Test conducted by Japan Steel Works testing laboratory under the witness of QC CWI Makhmud Ashadi.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
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Reviewed By:	Lanz,Joe	QA Reviewer
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